

Date: Tuesday, 11/21/2006 10:49:08 AM  
User: Kim Johnston

24/11

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 29559					
Estimate Number	: 12538					
P.O. Number	: N/A			Part Number	: D35461	
This Issue	: 11/21/2006 S.O. No. : N/A			Drawing Number	: D3546 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 28797			Material	: N/A	
Written By	: <i>ML</i>			Due Date	: 11/23/2006	
Checked & Approved By	: <i>ML 06/11/21</i>			Qty:	20	Um: Each
Comment	: Est Rev A New Issue 06-09-27 JLM					

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6-080-Sheet



Comment: Qty.: 0.2205 sf(s)/Unit Total : 4.4100 sf(s)

6061-T6 aluminum sheet .080-Sheet

Batch: M180997 M 06 11 21

(20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: A

ML 06 11 21

(20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M 06/11/21 (20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3546

SB 06/11/23 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:49:08 AM  
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Drawing Name: BRACKET

Job Number: 29559

Part Number: D35461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/20/2006 (17)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11/21 (17)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/4/2006 (17)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11/4/2006 (17)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/4/2006 (17)

Job Completion

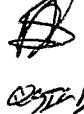


11/20/2006 (17)

→  
PTO

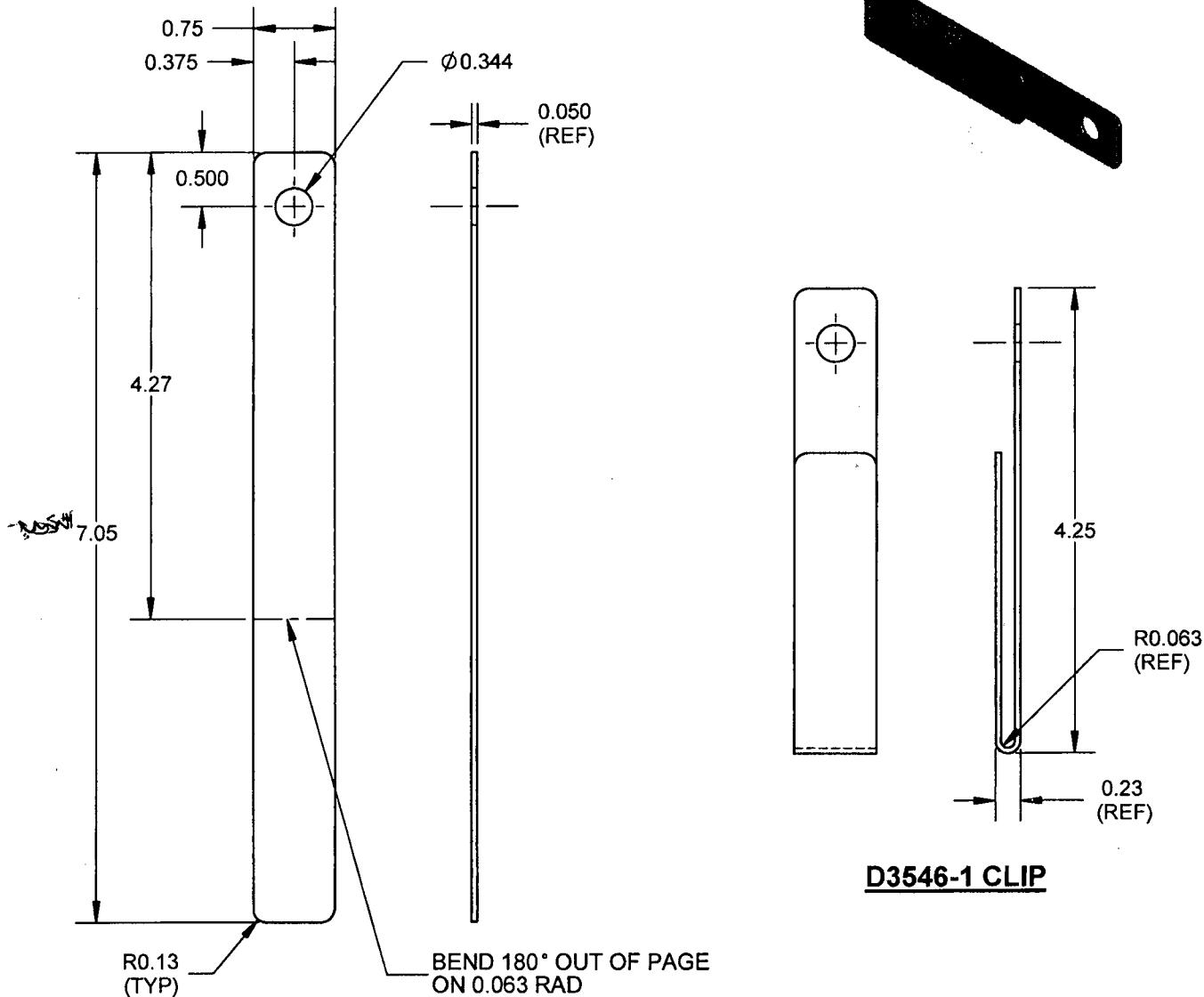
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/23	5	3 piece out of tolerance	 06/11/23	Scrap & destroy (Made a tool for bending)	SB 06/11/23	 06/11/23	 06/11/23	 06/11/23

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>QP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546
DATE 06.09.15		TITLE CLIP
REV A	DATE 06.09.15	SCALE 1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE



D3546-1 CLIP

D3546-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 29559

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DART AEROSPACE LTD	Work Order:	29559
Description: Bracket	Part Number:	D3546-1
Inspection Dwg: D3546 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by:	M.F. off
Date:	06/11/21

**Audited by:** AS

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	